

# Work Order ID 51520

August 25, 2009 1:34:56 PM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 8/28/09 Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan: *RD*

Date: *09-8-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *51520* Double check by: *mw* 1-Machine Step No 1  
per Folio FA051 and inspect per attached Dimension Sheets! 2-Machine Step  
No 2 per Folio FA051 and inspect per attached Dimension Sheets! 3-Machine  
Step No 3 per Folio FA051 and inspect

*SP 09/09/01*  
*GR*

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

*mw / SP*  
*09/09/16*

*27 0*

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*mw / SP*  
*09/09/16*

*22 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51520

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Page 2

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 8/28/09 Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

SL 09/09/16

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

SL 09/09/16 (22) Ø

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Memo

11/112260

0.00

SL 09/09/16 22 Ø

START TIME:

7:30am

OVEN TEMPERATURE:

8:00am FINISH TIME:

320°

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51520

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Page 3

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 8/28/09 Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*09-09-17*

*22*

170

Identify as per dwg & Stock Location: *433*

0.00



Packaging

Memo

0.00

Packaging

*9/9/09 22x Sp*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/09/22 MF 09-09-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 25, 2009 1:34:55 PM

Page 1  
1

Work Order ID: 51520

Parent Item: D2571RevE

Parent Item Name: Saddle, Fwd Out 205



Comments:

Start Date: 8/28/09

Required Date: 9/18/09

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			100	Each	0.0000	24.0000			
												
Saddle Billet												

Batch# B46412

MR 08/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.000		
F	0.490	0.510		.502	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.499	.503	.503		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.567	.567	.570	.570		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.494	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.129	.126	.126	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.257	.257		
S	0.115	0.135		.134	.129	.129	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.960	2.960		
V	0.230	0.250		.243	.242	.240	.240		
W	0.115	0.135		.135	.130	.130	.130		
X	0.308	0.313		.308	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.618	.618	.618	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.257	.257	.250	.250		
AE	1.375	1.395		1.385	1.385	1.386	1.386		
AF	0.115	0.135		.126	.125	.125	.125		
AG	0.240	0.280		.258	.260	.260	.260		
AH	0.240	0.260		.257	.257	.257	.257		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.035	.035	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	09/09/16

Audited by:	SL
Date:	09/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	62	78	84	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.506		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.501	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.871		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.130	.128	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.239	.240	.240		
W	0.115	0.135		.125	.129	.130	.130		
X	0.308	0.313		.310	.310	.310	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.355	.353		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.386	1.386	1.386		
AF	0.115	0.135		.125	.125	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.251	.251	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>SL</i>
Date:	07/09/01

Audited by:	<i>SL</i>
Date:	09/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	91	102	113	124		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.504	.506	.501		
G	0.257	0.262		.260	.260	.260	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.496	.496	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		.567	.565	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.873		
P	0.115	0.135		.127	.127	.127	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.255	.255	.250	.250		
S	0.115	0.135		.134	.133	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.239	.242	.243		
W	0.115	0.135		.130	.131	.130	.131		
X	0.308	0.313		.311	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.632	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.390	1.390	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.251	.248	.250	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SP
Date:	09/08/02

Audited by:	JL
Date:	09/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	214	215	216		
A	0.438	0.443		.446	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.502	.503	.500		
G	0.257	0.262		.259	.259	.259	.260		
H	0.375	0.380		.378	.377	.377	.378		
I	0.490	0.510		.500	.503	.498	.499		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.569	.568	.566	.566		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.128	.125	.122	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.247	.251	.249		
S	0.115	0.135		.130	.120	.128	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.230	.244	.241		
W	0.115	0.135		.130	.120	.132	.124		
X	0.308	0.313		.311	.310	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.350	.360	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.632	.630	.670		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.252	.247		
AE	1.375	1.395		1.387	1.389	1.380	1.386		
AF	0.115	0.135		.135	.135	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.257	.240	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	88
Date:	09/09/10

Audited by:	JK
Date:	09/09/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17 X	18 X	19 X	20 X		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.565	.565	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.251	.254	.254	.254		
S	0.115	0.135		.125	.132	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.128	.130	.130	.130		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.252	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *SP*  
Date: *07/09/15*

Audited by: *JK*  
Date: *09/09/16*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51520</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21A	22A	23A	24A	By	Date
A	0.438	0.443		.441	.441				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.501	.501				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.130	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.250	.250				
W	0.115	0.135		.125	.125				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.362	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.020	2.020				
AJ	0.023	0.043		.033	.033				
Accept/Reject									







Measured by: <i>SL</i>
Date: 02/09/16

Audited by: <i>SL</i>
Date: 09/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SL</i>

05.12.6 #

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. 06102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

51520

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS	DRAWN BY PH	<b>DART</b>	<b>DART AEROSPACE LTD.</b> HARRISBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2571	REV. SHEET 1 OF 2
DATE 05.07.13	TITLE OUTER FWD SADDLE		SCALE 2-

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DART AEROSPACE LTD.

DETAIL C  
SCALE 4:3